

# Work Order ID 72835

Tuesday, August 16, 2011 9:15:30 AM



Page 1

Item ID: D206-628-034

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step RH

Start Date: 8/16/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-08-16

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-034 CHG 003

5/11/09/20

MF 11-9-13

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

4/15/19

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

5/11/09/20

72837

+4  
24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 72835**

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Start Date: 8/16/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 8/26/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-628-034 Location: _____ PPP Rev: <u>0</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

*Relly/2011**11/9/2011**MP  
11-09-2011*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Tuesday, August 16, 2011 9:15:39 AM

Page 1

Work Order ID: 72835

Parent Item: D206-628-034

Parent Item Name: Heli-Access-Step RH

Start Date: 8/16/2011


Required Date: 8/26/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM  
 IPP Rev:E as per ecn 1118 08-02-05 DD verified by:EC  
 IPP rev F ncr 09-004 09.01.09 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------


AN3C4A  BOLT		Purchased	No			110	Each	1,361.000	3	12			
--	--	-----------	----	--	--	-----	------	-----------	---	----	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST350	1361	
117313	2	
117688	36	
117795	1	
117872	22	
118012	260	
118112	40	
118451	1000	

117795 16

1178451 116

AN4C14A  Bolt		Purchased	No			110	Each	52.0000	8	32			
--	--	-----------	----	--	--	-----	------	---------	---	----	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST337	2	
117688	2	
ST357	50	
118267	50	

117688 20

118267 300

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 72835

Parent Item: D206-628-034

Parent Item Name: Heli-Access-Step RH

Start Date: 8/16/2011

Required Date: 8/26/2011

Start Qty: 4.00

Required Qty: 4.00

AN4C15A

Purchased

No

110

Each

83.0000

4

16

Bolt

Location

Loc Qty

Loc Code

ST358

83

115835

2

117441

31

117795

50

AN960C416L

Purchased

No

110

Each

0.0000

24

WASHER

D2731-3

Manufactured

No

110

Each

60.0000

4

16

Mounting Lug

Location

Loc Qty

Loc Code

ST469

60

47967

37

52329

23

D2732

Manufactured

No

110

f

606.3981

2

8

Rubber Extrusion

Location

Loc Qty

Loc Code

ST410

606.39811

64283

107.52811

70987

498.87

3.00" long

D2842-042

Manufactured

No

110

Each

0.0000

1

4

Step Assembly RH, 206 Float

Shop Packet Print

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D206-628-034

Parent Item Name: Heli-Access-Step RH

Start Date: 8/16/2011

Required Date: 8/26/2011

Start Qty: 4.00

Required Qty: 4.00

D2844-2 Manufactured No

110 Each

13.0000

2 8



Arm

Location Loc Qty Loc Code

ST263 10

70541 10

ST265 3

62954 3

70541

D2844-3 Manufactured No

110 Each

12.0000

1 4



Arm

Location Loc Qty Loc Code

ST266 12

66822 12

66822

D3394-041 Manufactured No

110 Each

26.0000

4 16



Lug Assembly

Location Loc Qty Loc Code

ST 3

ST474 26

68257 26

68257

MS21043-4 Purchased No

110 Each

969.0000

12 48



Nut

Location Loc Qty Loc Code

FG 40

104603 40

ST301 929

117793 482

118378 447

118378

Tuesday, August 16, 2011 9:15:40 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Heli-Access-Step RH

Start Date: 8/16/2011

Required Date: 8/26/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149C0363R

Purchased

No

110

Each

4,217.000

3

12



Washer

Location

Loc Qty

Loc Code

ST297

4217

114742

4217

110

Each

250.0000

3

12

NAS1515H3

Purchased

No



Washer

Location

Loc Qty

Loc Code

ST277

250

116373

6

117460

58

118078

6

118384

180

110

Each

76.0000

24

96

NAS1515H4L

Purchased

No



WASHER

Location

Loc Qty

Loc Code

FG

36

103691

36

ST277

40

117363

40

113691 24

117363 34

1118209

~~502834~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

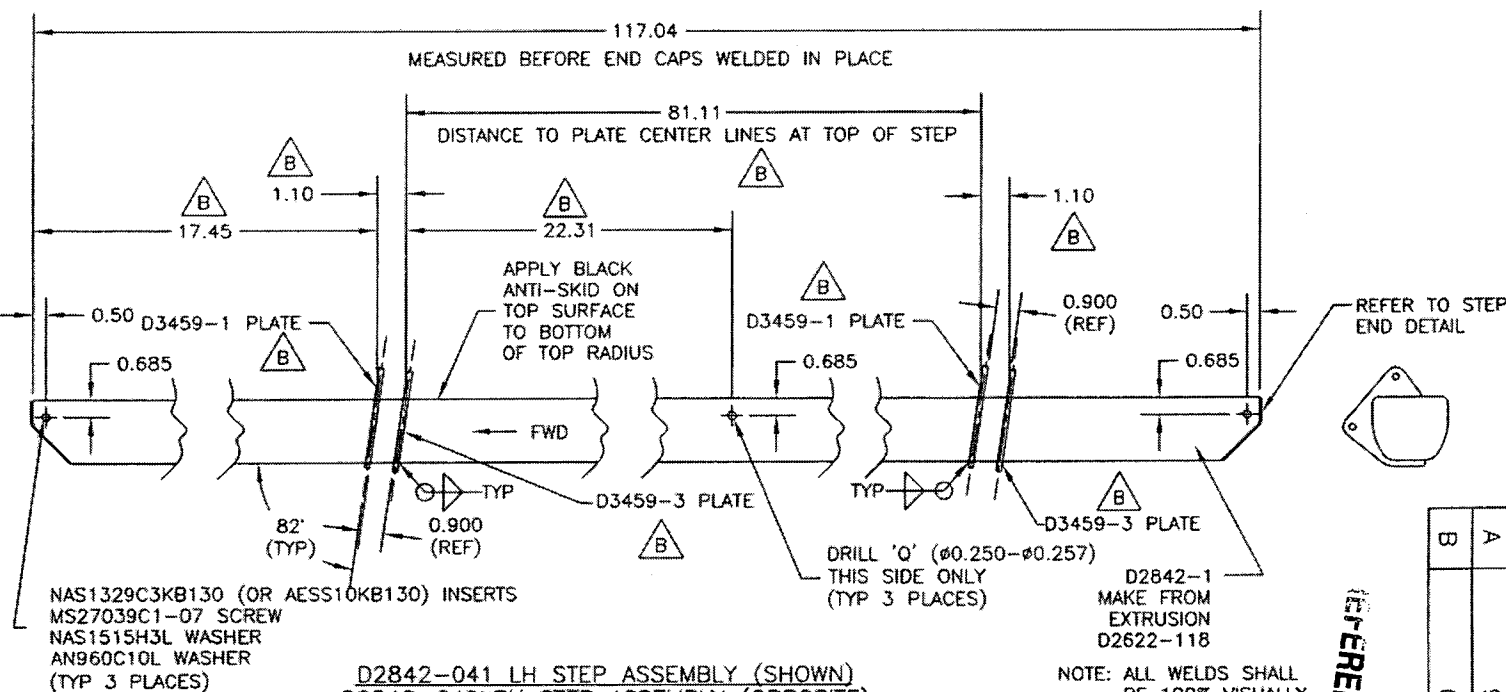
### 5.2 D206-628-013/-014/-023/-024/-033/-034 FLOAT COMPATIBLE DART HELI-ACCESS-STEPS™ PARTS LIST

Qty -013	Qty -014	Qty -023	Qty -024	Qty -033	Qty -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INST. LH
	X					D206-628-014	206 A/B FLOAT STEP INST. RH
		X				D206-628-023	206 L/L1/L3/L4 FLOAT STEP INST. LH
			X			D206-628-024	206 L/L1/L3/L4 FLOAT STEP INST. RH
				X		D206-628-033	407 FLOAT STEP INST. LH
					X	D206-628-034	407 FLOAT STEP INST. RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
1						D2841-041	FLOAT STEP ASSEMBLY LH
	1					D2841-042	FLOAT STEP ASSEMBLY RH
		1		1		D2842-041	FLOAT STEP ASSEMBLY LH
			1		1	D2842-042	FLOAT STEP ASSEMBLY RH
		2	2	2	2	D2844-1	ARM
		1	1	1	1	D2844-3	ARM
2	2					D2845	ARM
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*LUG
4	4			8	8	*MS35489-93	*GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*LUG
8	8	8	8			*MS35489-93	*GROMMET
1	1					D4064-041	MOUNTING LUG
1	1					*D4064-1	*LUG
2	2					*MS35489-93	*GROMMET
2	2	3	3	3	3	AN3C4A	BOLT
4	4					AN4C13A	BOLT
4	4	4	4	8	8	AN4C14A	BOLT
4	4	8	8	4	4	AN4C15A	BOLT
2	2	3	3	3	3	NAS1149C0363R	WASHER (OR AN960C10)
16	16					NAS1149C0463R	WASHER (OR AN960C416)
8	8	24	24	24	24	NAS1149C0432R	WASHER (OR AN960C416L)
24	24	24	24	24	24	NAS1515H4L	WASHER
12	12	12	12	12	12	MS21043-4	*NUT
2	2	3	3	3	3	NAS1515H3	WASHER

\*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

### 5.3 QUICK RELEASE PIP PIN KIT

Qty -011	Part Number	Description
X	DSI9235-011	QUICK RELEASE PIP PIN KIT
4	BLRS-020	QUICK RELEASE PIN

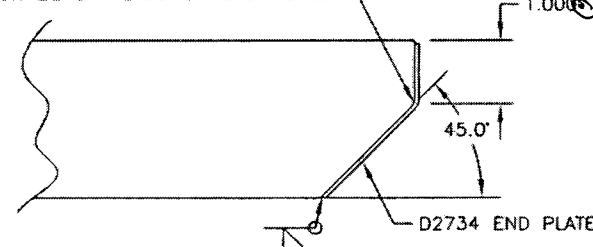


D2842-041 LH STEP ASSEMBLY (SHOWN)  
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

**D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST**

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-11B	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL  
NOT TO SCALE

**D2842-041/-042 FLOAT STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

REFERENCE ONLY

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.23	TITLE	D2842	REV. B
			206L/407 FLOAT STEP ASSEMBLY	SHEET 1 OF 1
			NEW ISSUE	SCALE
			RE-DESIGN, ADD D3459-1/-3	NTS

RELEASED  
05.11.14